

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017748**Date Inspected:** 26-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (10BE-10CE)

This QA inspector witnessed the final bolt tension verification on the retrofit plate installed on side and bottom panel across transverse splice of E4 work point. The torque wrench S/N was X02-666.The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 91 to PP 92:

M24 X 60 – DHGM 240014 – 567 NM

M24 X 85 – DHGM 240019 – 550 NM

M24 X 90 – DHGM 240076 – 474 NM

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection to verify the root gap and offset on the transverse splice weld of segment 11BE and segment 11CE. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

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Segment 11BE to Segment 11CE – PP 100 to PP 101

OBG # TRIAL ASSEMBLY YARD (11BW-11CW)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection to verify the root gap and offset on the transverse splice weld of segment 11BW and segment 11CW. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BW to Segment 11CW – PP 100 to PP 101

OBG # TRIAL ASSEMBLY YARD (CB13)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection to verify the gap between the skin plate of Cross Beam to the Segment 10AE FL3 and Segment 10AW FL3. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The cross beam and panel point designations were as follows:

CB13- PP 86 and PP 88

OBG # TRIAL ASSEMBLY YARD (CB14)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection to verify the gap between the skin plate of Cross Beam to the Segment 10CE FL3 and Segment 10CW FL3. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The cross beam and panel point designations were as follows:

CB14- PP 92 and PP 94

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11BE)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) over head position on corner assembly piece mark no. CA084. The location was the hold back area of longitudinal weld joining the Edge to Deck panel of segment 11BE. The welder ID was 040320. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11CE)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 006 in the (4G) over head position on corner assembly piece mark no. CA088. The location was the hold back area of longitudinal weld joining the Edge to Deck panel of segment 11CE. The welder ID was 040320. The ZPMC CWI was identified as

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Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 007 in the (3G) vertical position on side panel piece mark no. OBW11B. The location was the transverse splice weld joining segment 11BW and 11CW. The welder ID was 047353. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
